

Work Order ID 61835

Tuesday, September 07, 2010 3:16:32 PM



Page 1

Item ID: D3912-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Block

Start Date: 9/7/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-9-08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3912

B

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 2.50" LONG

SL 10/09/24

12

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA870 AND DWG

FOLIO REV: AA

DWG REV: B

DEBURR

SL 10/09/29


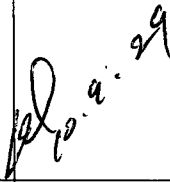
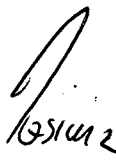
12

1

PTC 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3912-3 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: _____ Date: 10/09/29
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 10/09/30

NCR: 61835		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/09/28	110	1 part popped out of vice while facing on 2nd off - operator change all inserts on Face mill to HSS no problems R.C. process: Tool pulled up part		- scrap replace Qty of B 113341	SL 10/09/29			S 10/09/29

NOTE: Date & initial all entries

Work Order ID 61835

Tuesday, September 07, 2010 3:16:32 PM



Page 2

Item ID: D3912-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Block

Start Date: 9/7/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	SL	10/09/29					
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	ml	10-9-29		12			
160 Packaging Packaging	Identify as per dwg & Stock Location: 090 Memo	0.00 0.00							12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61835

Tuesday, September 07, 2010 3:16:32 PM



Page 3

Item ID: D3912-3**Accept****Setup Start****Revision ID:****Stop****Item Name:** Eyebolt Block**Start Date:** 9/7/2010 **Start Qty:** 12.00**Cust Item ID:****Required Date:** 9/13/2010 **Req'd Qty:** 12.00**Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/30 [Signature]
MP
10-9-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 07, 2010 3:16:38 PM

Page 1

Work Order ID: 61835



Parent Item: D3912-3



Parent Item Name: Eyebolt Block


Start Date: 9/7/2010

Required Date: 9/13/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000  303 BAR 1" X 1"		Purchased	No			100	f	13.2292	0.208	2.627368			



SL 10/09/24

Location

Loc Qty

Loc Code

MAT

12

115555

12

MAT53

1.22922

113341

0.00026

113719

1.22896

2.63

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

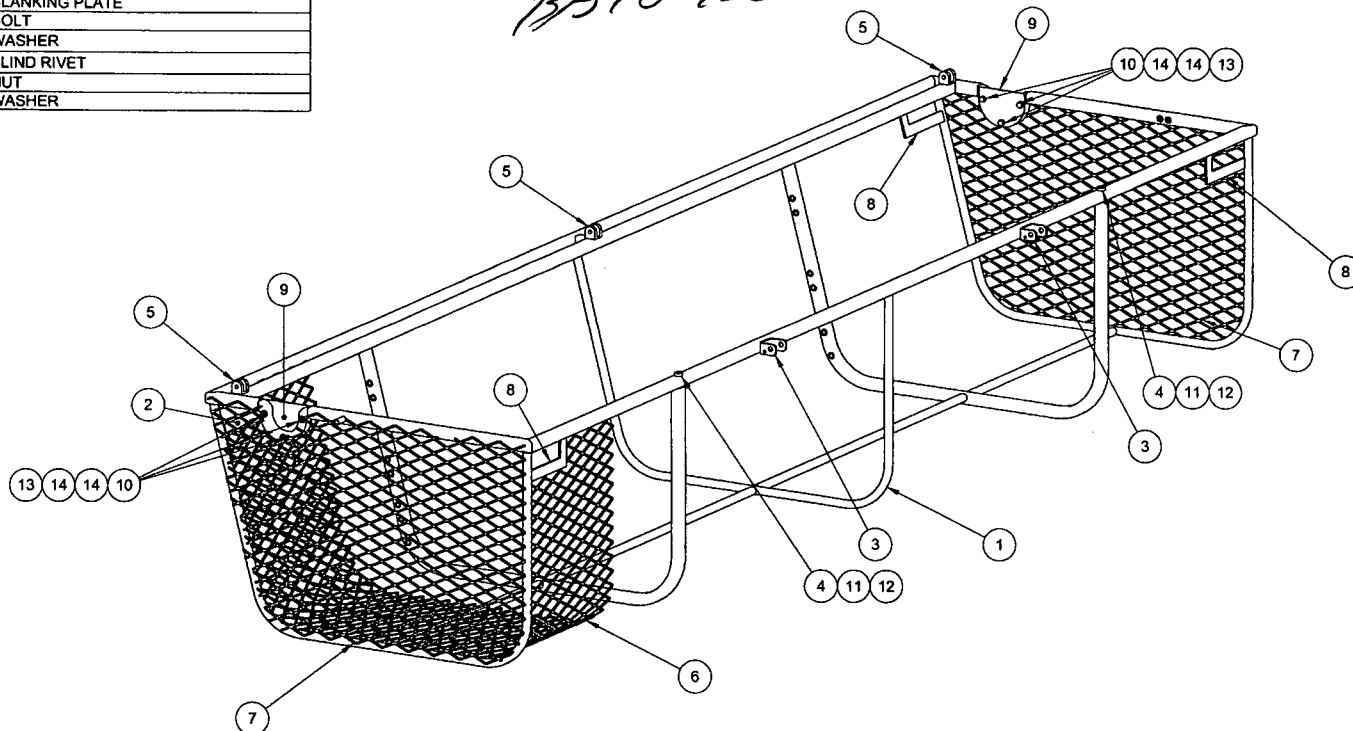
WITHOUT NOTICE

WORK ORDER

NO. 61835

B810-9-06

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JMH

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3913** REV. A
SHEET 1 OF 6
TITLE **LONG BASKET BASE ASSY (350) NTS**
SCALE

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2

D A7-3
D
D8-2 C
D4020-1
MESH

30.00

34.50

2 PL

D2581
MOUNTING BRACKET
2 PL

D2931 BUMPER
AN960JD8 WASHER
MS20600AD4W3 RIVET
2 PL (8)

D3913-101
TUBULAR ASSY

w/06/835

0.75
D4021-1
HANDLE PLATE

A

45.94

45.94

D4016-1
HINGE HALF, BASE
3 PL

3 PL

D4021-1
HANDLE PLATE
2 PL

C7-3 A

C3-3 B

D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-05-27

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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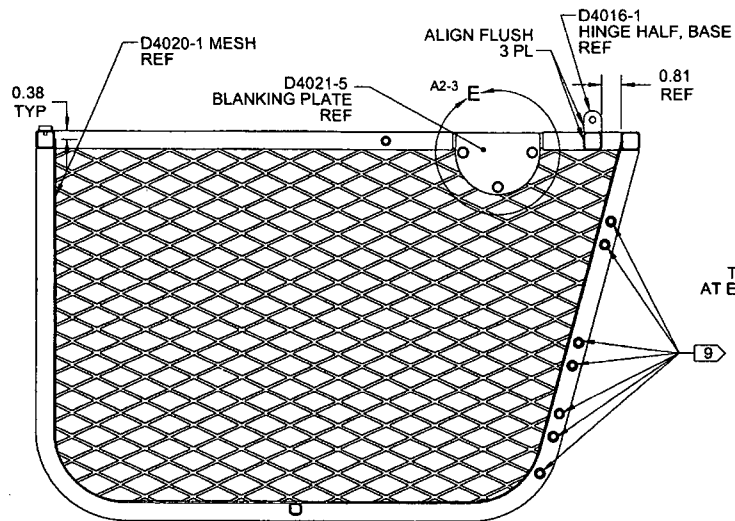
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

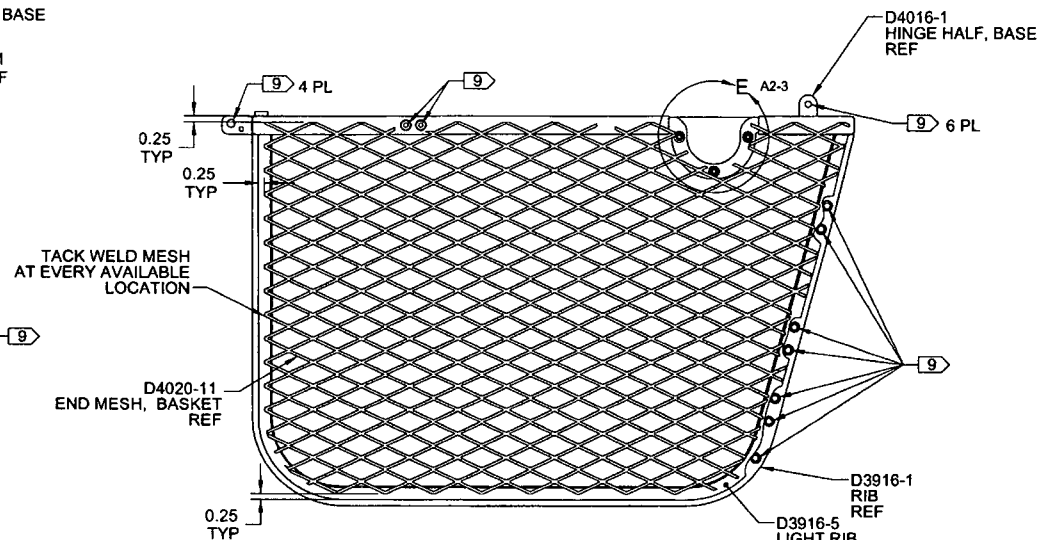
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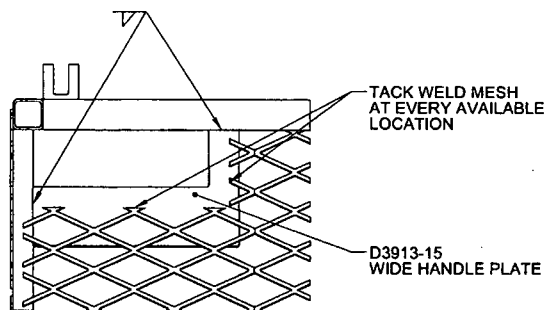
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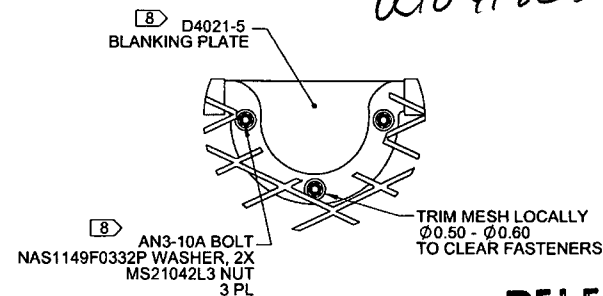
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL D2-3
D6-3

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CHECKED		DRAWING NO.	REV. A
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2010-03-22

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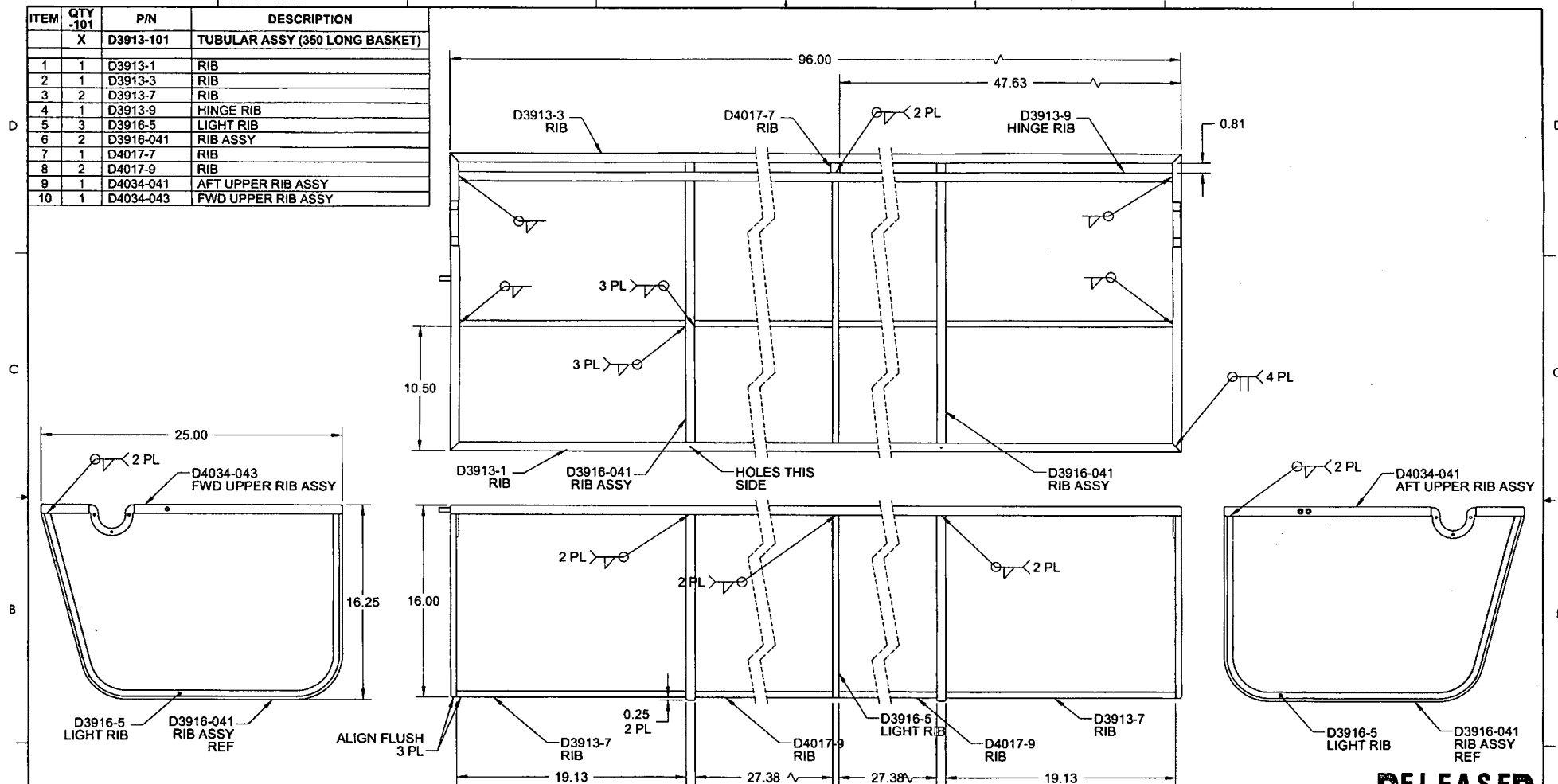
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

RELEASED
2010-03-22

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DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
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DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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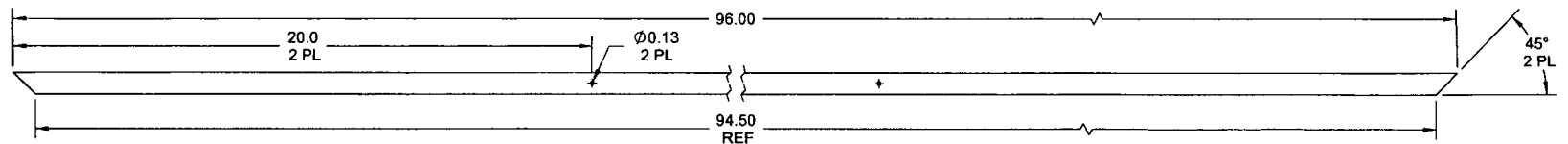
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

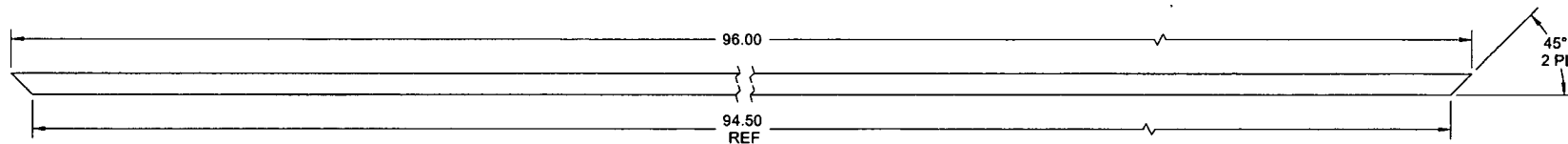
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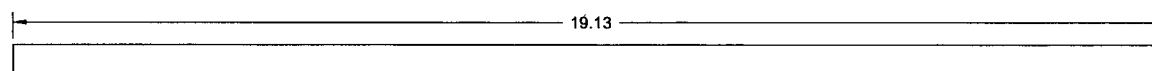
NOTE: Date & initial all entries



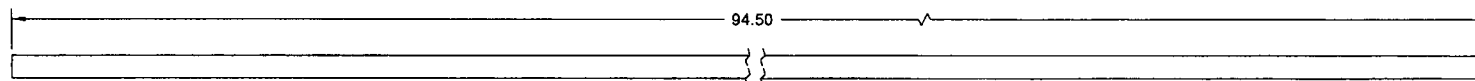
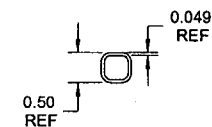
D3913-1 RIB



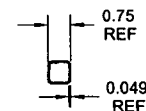
D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB



NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	HA	D3913	SHEET 5 OF 6
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DE APPR.	HA	LONG BASKET BASE ASSY (350) NTS	
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2010-03-22

w/o 61835

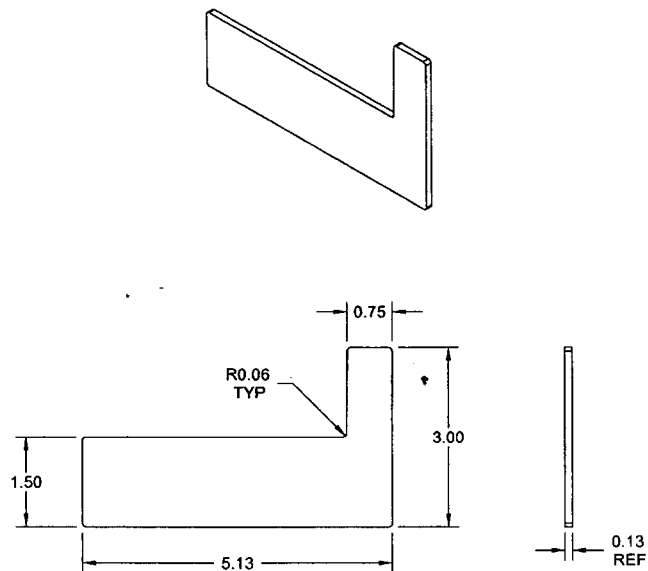
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			





NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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2010-03-22

W/O 61835

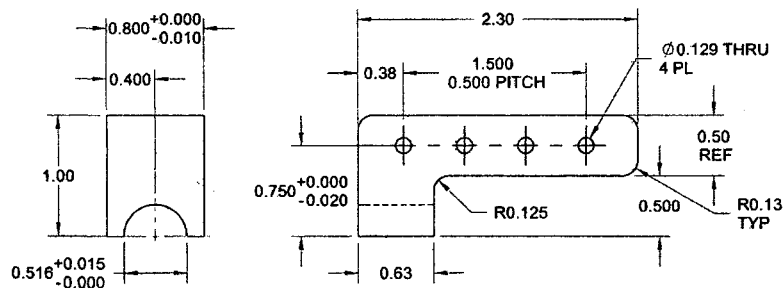
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

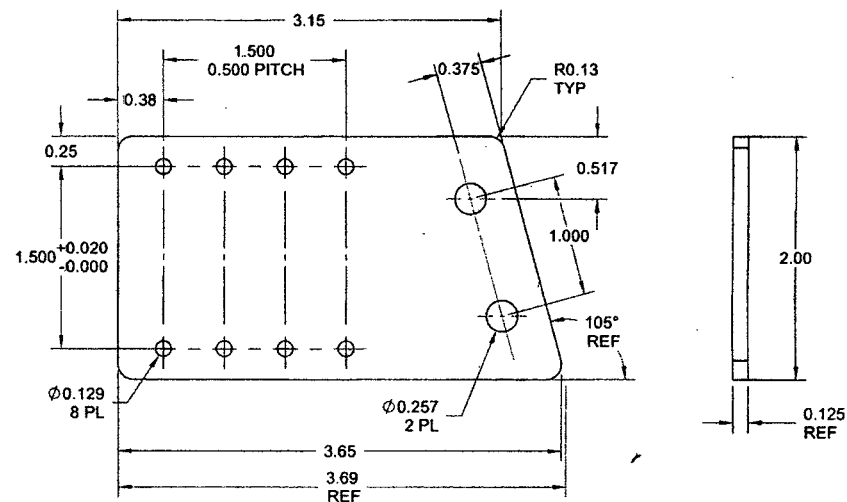
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16
and

DESIGN	<i>1.15</i>	DART AEROSPACE LTD	
DRAWN	<i>1.15</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>1.15</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>1.15</i>	D3912	SHEET 3 OF 3
APPROVED	<i>1.15</i>	TITLE	SCALE
DE APPR.	<i>1.15</i>	EYEBOLT RECEIVER ASSY	NTS
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